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D4436-045
Job Sheet 178142



Part No: D4436-045

Job Qty: 6 ea

Part Name: Aft Inboard Bracket Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/27/18

Job Tracking No:

Due Date: 6/8/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP revA 11.10.06 new issue EC verified by:DD IPP RevB 11.12.22 per PA2 EC verified by:JLM
IPP REV:C 12.01.24 PER DWG REV.A DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	6/8/18	6/8/18	0.00	0.00	Start Up Waterjet		SL 18/05/18
100	Waterjet	6 pcs	6/8/18	6/8/18	0.00	1.07	Waterjet1		SL 18/05/18
110	QC	6 pcs	6/8/18	6/8/18	0.00	0.00	QC2 Waterjet-3		SL 18/05/18
120	QC	6 pcs	6/8/18	6/8/18	0.00	0.00	QC8-4		38
130	Brake NC	6 pcs	6/8/18	6/8/18	0.08	0.83	Brake NC 2		9-88
140	Small Fab	6 pcs	6/8/18	6/8/18	0.00	1.17	Small Fab-6 N/A		DAS
150	QC	6 pcs	6/8/18	6/8/18	0.00	0.00	QC5		38
160	HandFinish	6 pcs	6/8/18	6/8/18	0.00	0.52	HandFinish1		BEB 18-06-20
170	QC	6 pcs	6/8/18	6/8/18	0.00	0.00	QC7-3		38
180	Small Fab	6 pcs	6/8/18	6/8/18	0.00	1.17	Small Fab-6		DAS
185	QC	6 pcs	6/8/18	6/8/18	0.00	0.00	QC5		38
190	Powdercoat	6 pcs	6/8/18	6/8/18	0.00	0.30	Powdercoat4		BK 18-06-20
200	QC	6 pcs	6/8/18	6/8/18	0.00	0.00	QC3		Smp
202	Small Fab	6 pcs	6/8/18	6/8/18	0.00	1.17	Small Fab-6		Smp
205	QC	6 pcs	6/8/18	6/8/18	0.00	0.00	QC5		38
210	Packaging	6 pcs	6/8/18	6/8/18	0.00	0.00	Packaging3-2	5/620	9-88
220	QC21-SA	6 Ea	6/8/18	6/8/18	0.00	0.00	QC21		DAS 21 JUN 21 2018

M 138700

START: 2:20

OUT: 3:30 FINISH: 2:50

5068615

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.040	6061-T6 .040 Sheet	4.1340 sf (.689 ea)	90-Start up Operation	
MS20426AD3-3	Rivet	24 Ea (4 ea)	180-Small Fab	5018535
MS20470AD4-3	Rivet, Universal Head	12 Ea (2 ea)	180-Small Fab	FM135536-2
MS21075L08	Anchor Nut	12 Ea (2 ea)	180-Small Fab	5050045
D4441-1	Rubber Seal	6.9000 ft (1.15 ea)	202-Small Fab	FIS1347
MS35489-19	Grommet	6 Ea (1 ea)	202-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.040	4	239	0
180-Small Fab	MS20426AD3-2	24	384	0
	MS20470AD4-3	12	206	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Composite ☐	Supplier ☐				

Date : _____ Step #: _____

MRB (QSI042) Approval

Description Work Order Deviation



Root Cause					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐			
Design ☐	Operator ☐	Bending ☐			
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐			
Equip/Tooling ☐	Supplier ☐	Cracks ☐			
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐			
Material ☐	Use for Testing ☐	Cuffs ☐			
Internal Transport ☐	Poor Information ☐	Crushing ☐			
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐			
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐			
Substation ☐	Process Improvement ☐	Marks/Chatter ☐			
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐				
			OTHER : _____		

202-Small Fab	MS21075L08	12	230	0
	D4441-1	7	70	0
	MS35489-19	6	106	0

Part Specifications

Specifications could not be found.

Plex 5/28/18 7:32 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐					

FIRST ARTICLE INSPECTION CHECKLIST

Measured by: SC		Audited by: 38 9-88		Preliminary Approval:		
Date: 8/05/31		Date: JUN 06 2018		Date:		
Rev	Date	Change			Revised by	Approved
A	15.10.14	New Issue			KJ	